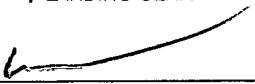


Date: Thursday, 15/03/2007 8:08:45 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER BLOCK	
Job Number : 28517A	Part Number : D3193041	
Estimate Number : 10251	Drawing Number : D3193 REV B	
P.O. Number : N/A	Project Number : N/A	
This Issue : 15/03/2007	Drawing Revision : B	
Prsht Rev. : NC	Material : N/A	
First Issue : 13/09/2006	Due Date : 02/10/2006	
Previous Run : 25004A	Qty: 8 Um: Each	
Written By : 		
Checked & Approved By :		
Comment : Est Rev:A New Issue 05-11-05	JLM	
Additional Product		
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2500X03500	6061-T6 Bar 2.5" x 3.5"
		
Comment: Qty.: 0.5156 f(s)/Unit Total : 4.1244 f(s) Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x03.500) Identify for D3193-1 Batch: 		
2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW Cut blanks: 3.500" x 2.500" x 5.900" long Bar		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1 2-Deburr and Tumble		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK		

Date: Thursday, 15/03/2007 8:08:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BLOCK

Job Number: 28517A

Part Number: D3193041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(8X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-f

07/03/15

7.0 POWDER COATING

POWDER COATING



(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f

07/03/15

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(X)

9.0 MS20426AD35

Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick:

Qty Part Number

1g MS20426AD35

Description Batch

Rivet M-1179

M17694

X

10.0 MS21073L4

NUTPLATE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

4g MS21073L4

Description Batch

Nut Plate M18728

X

SB 07/03/21

(8)

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3193-041 as per Dwg D3193

SB 07/03/21

8

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Date: Thursday, 15/03/2007 8:08:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BLOCK

Job Number: 28517A

Part Number: D3193041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

DA 13/22

Job Completion



U 07.03.22

Date: Wednesday, 9/13/2006 4:29:33 PM
 User: Kim Johnston

Process Sheet

No second check
on this one

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	SPACER BLOCK		
Job Number	28517A			Part Number	D3193041		
Estimate Number	10251			Drawing Number	D3193 REV B C 06-09-22		
P.O. Number				Project Number	N/A		
This Issue	9/13/2006 S.O. No. :			Drawing Revision	B		
Prsh Rev.	NC			Material			
First Issue	/ / Type : LANDING GEAR			Due Date	10/2/2006 Qty: 8 Um: Each		
Previous Run	25004A			Written By			
Comment	Est Rev:A New Issue 05-11-05 JLM			Checked & Approved By			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2500X03500	6061-T6 Bar 2.5" x 3.5"
		Comment: Qty.: 0.5156 f(s)/Unit Total : 4.1244 f(s) Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x03.500) Identify for D3193-1 1 x M19067 → SF 07/03/13 Batch: M14805 ml 06/09/22 8
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: 3.500" x 2.500" x 5.900" long Bar → SF 07/03/13 ① ml 06/09/22 8
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1 2-Deburr and Tumble → SF/SF 07/03/13
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
5.0	POWDER COATING	POWDER COATING
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3193-041 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes ✓ No DQA: Date: 07/03/22
 QA: N/C Closed: Date: 07.03.23

NCR: <u>28517A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/13	3.0	origin was off on the hole hole position when the part was put back into the machine to open up the holes. Holes are oval. Open for error, i. tool O.D. was changed due to sharpening.	<u>S. Jaiswal</u> <u>05/04/13</u>	Sivap: destroy/replace. Ensure hole gets opened to proper sizes and origin is correct.	<u>J. P</u> <u>07/03/13</u>	<u>07/03/13</u>	<u>05/04/13</u>	<u>06.03.13</u>

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:29:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BLOCK

Job Number: 28517A

Part Number: D3193041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0	MS20426AD35	Rivet
-----	-------------	-------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
16 MS20426AD3-5	Rivet	_____

8.0	MS21073L4	NUTPLATE
-----	-----------	----------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
8 MS21073L4	Nut Plate	_____

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3193-041 as per Dwg D3193

10.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

11.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

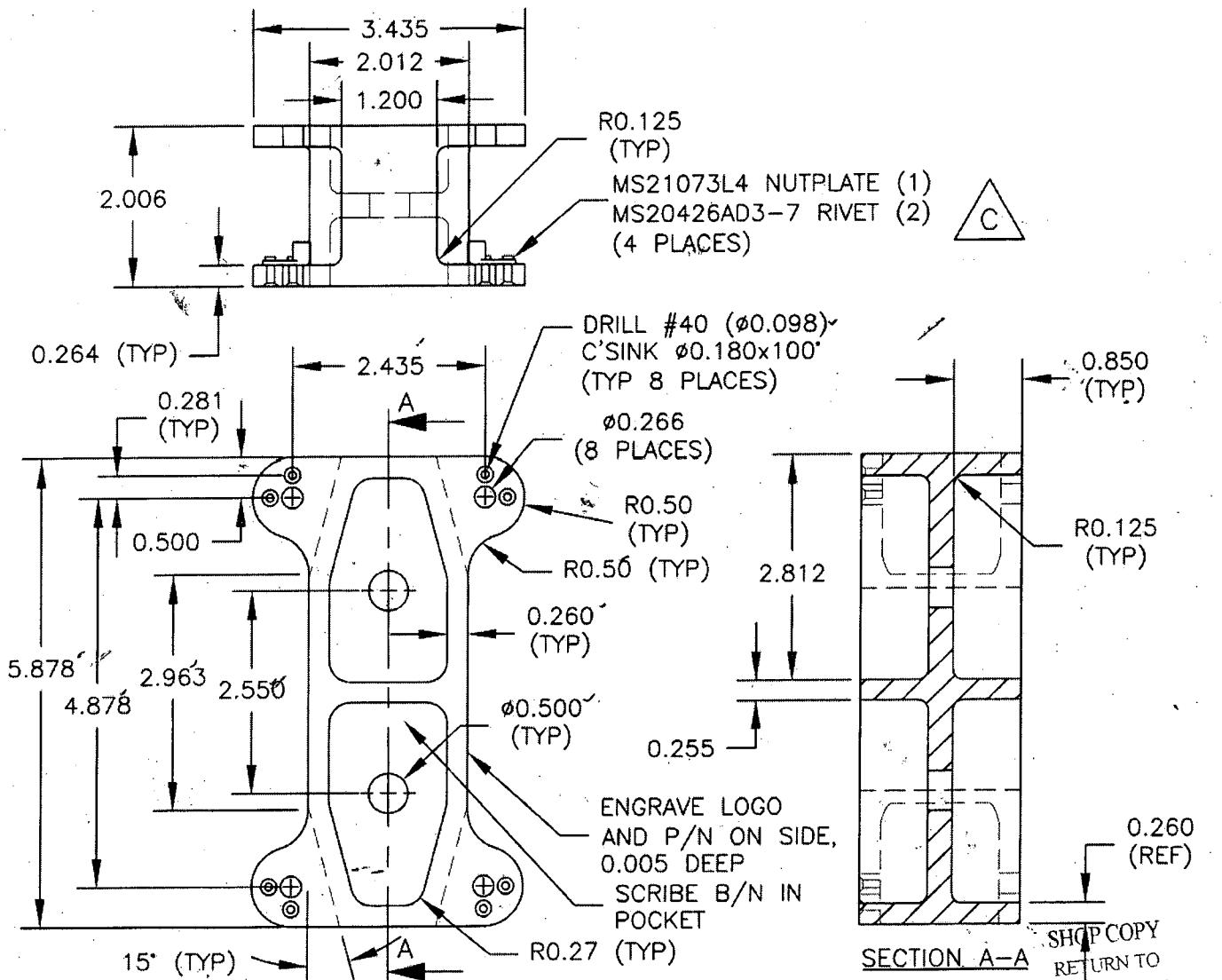
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>RF</i>	DRAWING NO. D3193	REV. C SHEET 1 OF 1
DATE 05.09.29		TITLE SUPPORT BRACKET ASSEMBLY	SCALE 1:2
A	03.06.09	NEW ISSUE	
B	03.12.22	MANUFACTURED BY DART	
C	05.09.29	MS20426AD3-7 WAS MS20426AD3-5	

RELEASED
05.09.30



D3193-041 SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET)

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *38517A*

DART AEROSPACE LTD	Work Order:	89517A
Description: SPACER Block	Part Number:	D3193041
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.878	+ .010	5.880	✓			
B 4.878	+ .010	4.881	✓			
C 2.963	+ .010	2.963	✓			
D 2.550	+ .010	2.551	✓			
E 2.435	+ .010	2.435	✓			
F 0.081	+ .010	.282	✓			
G 0.260	+ .010	.282	✓			
H 0.500	+ .010	.498	✓			
I .098	+ .005 - .001	.099	✓			
J 15.180 x 100°	+ .010	.182	✓			
K Ø.266	+ .001 - .001	.268	✓			
L R .270	+ .010	.272	✓			
M 2.006	+ .010	2.008	✓			
N 3.435	+ .010	3.437	✓			
O 2.012	+ .010	2.011	✓			
P 1.200	+ .010	1.202	✓			
Q 2.125	+ .010	2.125	✓			
R 0.850	+ .010	.850	✓			
S R0.125	+ .0010	.125	✓			
T 2.812	+ .010	2.812	✓			
U .255	+ .010	.252	✓			
V .260	+ .010	.259	✓			
W						
X						
Y						

Measured by:	J.R.	Audited by:	SD	Prototype Approval:	N/A
Date:	07/03/13	Date:	07.05.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

